



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2932-2

Job Sheet 180983



Part No: D2932-2

Job Qty: 4 ea

Part Name: Saddle RH Out, 206



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/19/18

Job Tracking No:

Due Date: 8/3/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP: B 00.06.26 New DWG rev (mpp 2069) EC IPP Rev:C As per Rev C 07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		8/3/18	0.00	0.00	Start Up Machining-1		UHB 8/8/17
100	CNC Vertical Machining	4 pcs		8/3/18	0.53	4.65	HAAS1-2		
110	Mill Conv	4 pcs		8/3/18	0.00	0.67	Mill Conv 1		
120	QC	4 pcs		8/3/18	0.00	0.00	QC1		
130	QC	4 pcs		8/3/18	0.00	0.00	QC8 Machining-1		2mm 18/08/18
140	HandFinish	4 pcs		8/3/18	0.00	0.22	HandFinish1		D.R 18/08/18
150	Powdercoat	4 pcs		8/3/18	0.00	0.16	Powdercoat1		12-08-18
160	QC	4 pcs		8/3/18	0.00	0.00	QC3		AUG 15 2018
170	Packaging	4 pcs		8/3/18	0.00	0.00	Packaging3-1		AUG 16 2018
180	QC21-SA	4 Ea		8/3/18	0.00	0.00	QC21		AUG 16 2018

Part Op 100 - Program part number and batch number.
Descriptions: 110 - Machine Keyway and inspect per attached dimension sheet
120 - Inspect on CMM as per folio CMMA014.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-003	Saddle Billet, 7075	4 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-003	4	95	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS				
	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐		

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval
Description Work Order Deviation		Disposition	Completed By
			Lead hand / Supervisor Approval Verification
			QC / QA Coordinator Approval

Internal
Tribal K
S
Past Ex
Misi

DART
AEROSPACE

Container No: S099759
Part: D2932-2
Job No: 180983
Serial No/Batch: S099759

Revision:
Inspector:
Exp Date:
Instructions: Various STC's

DATE: 08/07/18

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DEFECT CATEGORY

Qualified	☐ Power Loss/Surge	☐ Positioned Wrong
	☐ Folio/Program	☐ Outside Dimensions
	☐ Grain	☐ Over/Under tolerance
	☐ Weld	☐ Part Incorrect
	☐ Wrong Stock Pulled	☐ Part Lost/Missing
Clear	☐ Out of Sequence	☐ Part Moved
	☐ Off-set	☐ Drawing
	☐ Misabeled	☐ Finish
	☐ Fit/Function	☐ Misread
	☐ Misaligned/off center	☐ Turning Sequence

DART AEROSPACE LTD	Work Order:	180983
Description: 206 Saddle, Outboard, Right side	Part Number:	D2932-2
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.120	0.127	0.120	0.120		
B	0.100	0.140		0.120	0.127	0.120	0.120		
C	0.100	0.140		0.115	0.122	0.115	0.115		
D	0.210	0.230		0.227	0.227	0.227	0.226		
E	1.245	1.255	✓	1.250	1.250	1.250	1.250		
F	1.245	1.255	✓	1.250	1.250	1.250	1.250		
G	2.495	2.505	✓	2.500	2.500	2.500	2.500		
H	0.510	0.515		0.510	0.511	0.511	0.511		
I	1.572	1.582	✓	1.575	1.575	1.575	1.575		
J	2.495	2.505	✓	2.500	2.500	2.500	2.500		
K	0.257	0.262	✓	0.257	0.257	0.257	0.257		
L	0.312	0.317	✓	0.312	0.312	0.312	0.312		
M	0.235	0.240		0.239	0.239	0.239	0.239		
N	0.100	0.140		0.118	0.119	0.118	0.120		
O	0.540	0.560		0.5485	0.549	0.549	0.548		
P	0.490	0.510		0.501	0.500	0.502	0.502		
Q	3.715	3.725	✓	3.720	3.720	3.720	3.720		
R	2.470	2.510	✓	2.500	2.500	2.500	2.500		
S	0.240	0.270		0.265	0.265	0.263	0.264		
T	0.100	0.180		0.135	0.135	0.135	0.135		
U	1.625	1.635	✓	1.630	1.630	1.630	1.630		
V	1.362	1.372	✓	1.367	1.367	1.367	1.367		
W	0.316	0.321	✓	0.316	0.316	0.316	0.316		
X	1.125	1.145	✓	1.130	1.130	1.130	1.130		
Y	1.565	1.585	✓	1.575	1.575	1.575	1.575		
Z	0.178	0.198	✓	0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	
Date:	

Audited by:	mmk
Date:	18/08/12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER: ☐ _____							